

Order 8354

Ship 3a07



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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C60-19C

Job Sheet 181278



Part No: C60-19C

Job Qty: 1 ea

Part Name: Weldment



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/24/18

Job Tracking No:

Due Date: 7/31/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: C60-19C REV.3 IPP REV:A 18.02.02 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		7/31/18	0.00	0.00	Start Up Large Fab-7		
100	Large Fab	1 pcs		7/31/18	0.00	10.00	Large Fab 8		
110	QC	1 pcs		7/31/18	0.00	0.00	QC9		
120	QC	1 pcs		7/31/18	0.00	0.00	QC5		
130	Powdercoat	1 pcs		7/31/18	0.00	0.50	Powdercoat6		
140	QC	1 pcs		7/31/18	0.00	0.00	QC3		
150	Packaging	1 pcs		7/31/18	0.00	0.00	Packaging3-2		
160	QC21-SA	1 Ea		7/31/18	0.00	0.00	QC21		

Part Op 100 - MANUFACTURE AS PER DWG, TACK WELD FOR INSPECTION BY: Cpc USE WELDING JIG C45/60.
Descriptions: ***ALL HOLES MUST ALIGN***

130 - START TIME: 2:30pm OVEN TEMPERATURE: 320°F FINISH TIME: 3:00pm

Job BOM

004689

Part / Item	Component Name	Quantity	Operation	Container
C45-18-1	Lifting Plate	2 Ea (2 ea)	90-Start up Operation	
C45-18-5	Boss	2 Ea (2 ea)	90-Start up Operation	<u>5071516</u>
C60-18-6	Bumper Bracket	1 Ea (1 ea)	90-Start up Operation	<u>5060331</u>
MT-A513-T-1.000W0.120	A513 Seamless Alloy Steel Round Tubing 1"dia. x 0.120" Wall	10.5000 ft (10.5 ea)	90-Start up Operation	<u>5045667</u>
				<u>5068088</u>

Locations



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Required	Inventory	Allocated
2	12	0
2	12	0
1	3	0
11	165	0

Container No: S096914



Part: C60-19C

Job No: 181278

Serial No/Batch: S096914

Revision: 3

Inspector:

Exp Date:

Date: 07/27/18

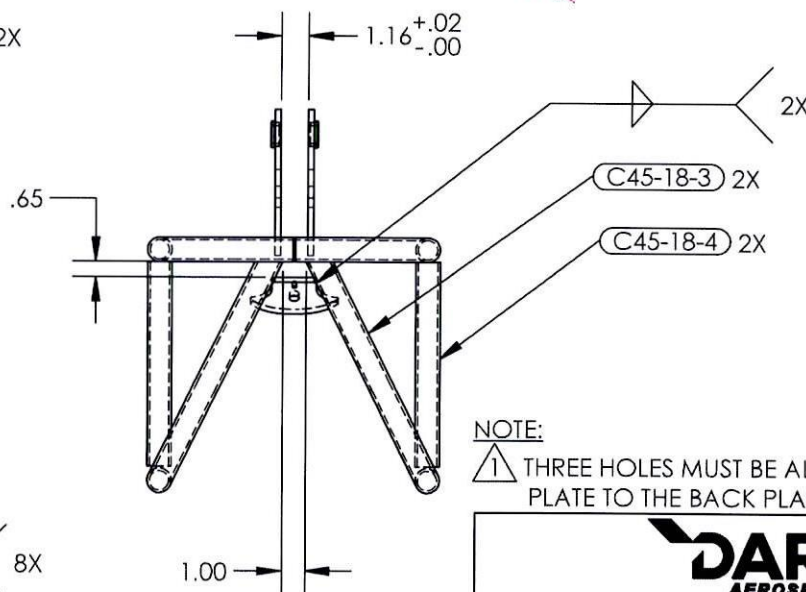
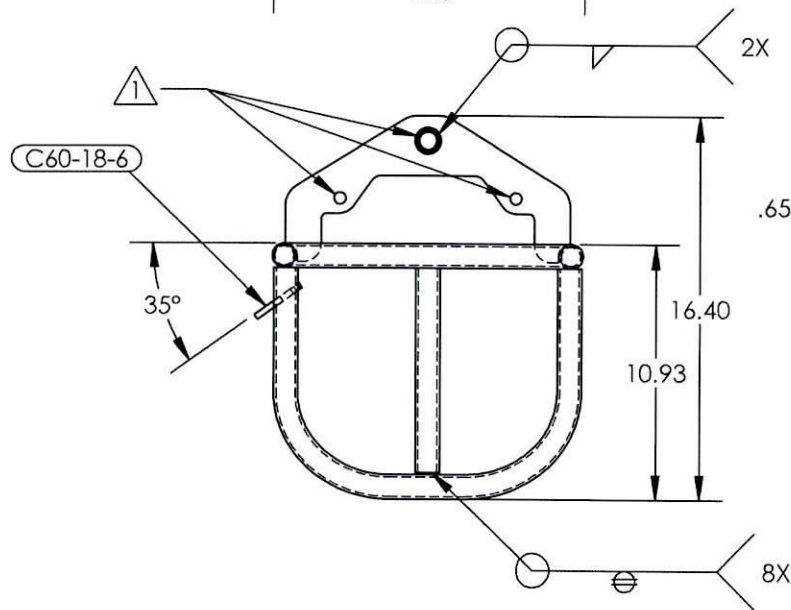
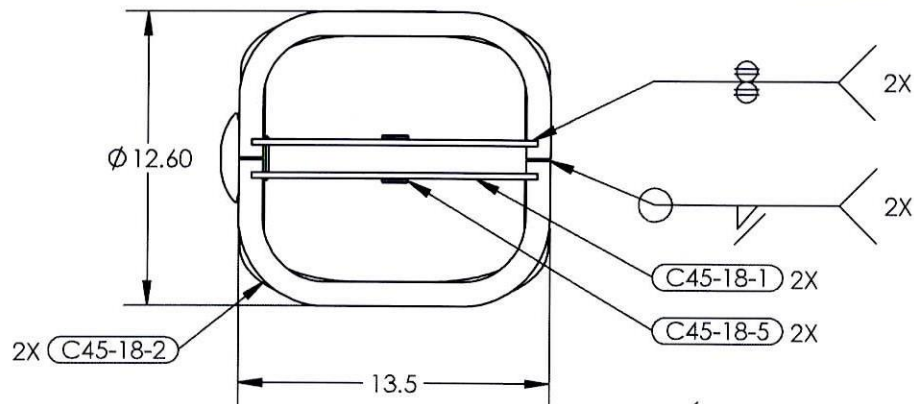
Locations

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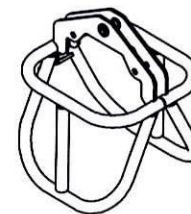
Plex 7/24/18 12:36 PM Dart.lajeunesse.marie

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
2		AS DRAWN BY APICAL.	11/6/2012	JAG
3	15-0182	UPDATED TO NEW DRAFTING STANDARDS. CH'D DIMS WAS 14.40 IS 16.40, WAS 1.79 IS .65, WAS 1.14 IS 1.16 +.02 -.00. DELETED DIM .250. ADDED DIM 35°.	7/22/2015	DPD



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WITHOUT NOTICE
WORK ORDER
NO. 181278
MCS
1807-24



NOTE:

△ THREE HOLES MUST BE ALIGNED FROM FRONT PLATE TO THE BACK PLATE.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material
			C45-18-1	2	LIFTING PLATE	1018/1020
			C45-18-2	2	TOP SEMI-RING	CARBON STEEL CDS
			C45-18-3	2	SIDE LOOP	CARBON STEEL CDS
			C45-18-4	2	STIFFENER BAR	CARBON STEEL CDS
			C45-18-5	2	BOSS	1018/1020
			C60-18-6	1	BUMPER BRACKET	1018/1020

C60-19C

WELDMENT

DART AEROSPACE	
TITLE WELDMENT	
DWG NO. C60-19C	REV 3
MATERIAL UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1	
DRAWN BY: APICAL INDUSTRIES APPROVED <i>D Wed</i> HEAT TREAT FINISH POWDERCOAT RED SPEC RAL 3000 USED ON MODEL	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:8	DATE 7/21/2009
SHEET 1 OF 1	